

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020819**Date Inspected:** 21-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhong Guo Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

Bay 16 / Steel Barrier

During in process inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Magnetic Particle Testing (MT) on Steel Barrier W5-SB1-010. See attached photograph Pic_001.

Bay 16 / Steel Barrier

During in process inspection this QA Inspector observed ZPMC NDT personnel performing Ultrasonic Testing (UT) on Steel Barrier W5-SB1-007. See attached photograph Pic_002.

Bay 14 / OBG Segment 13CE

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of weld joint VP3007-001-045 located on Vertical Plate. The welder is identified as 067520. ZPMC Quality Control (QC) is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the WPS B-T-2232-TC-U4b-F.

Bay 14 / OBG Segment 13CE

WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of weld joint VP3008-002 located on Vertical Plate. The welder is identified as 044801. ZPMC Quality Control (QC) is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the WPS B-T-2232-TC-U4b-F.

Bay 14 / OBG Segment 14W

This QA Inspector observed the following work in progress:

Sub Arc Welding (SAW) in the 1G position of weld joint SEG3020AQ-029 located on AP3015 to AP3016. The welder is identified as 45246. ZPMC Quality Control (QC) is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the WPS B-T-2221-B-L2c-S-2.



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
